

Work Order ID 77776

December-21-11 9:50:43 AM

77776

Page 1

Item ID: D2435

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw, 206

Start Date: 21/12/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 06/01/2012 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 11/12/21 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2435	Rev E1

120 0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

B12-1-10

(10)

130 0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

F.K. 12/02/22

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Deburr

140 0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

F.K. 12/02/22.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77776

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Page 2

Item ID: D2435 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw, 206
 Start Date: 21/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 06/01/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00	2	12-2-25		10	7		
Quality Control									

151	Identify as per dwg & Stock Location: _____	0.00							
151									
Packaging	Memo	0.00							
Packaging									

10x 12-02-27 JP

PPP 77775

190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/2/27 JP

12-02-27
 10

Dart Aerospace Ltd

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Picklist Print

December-21-11 9:50:49 AM

Page 1

Work Order ID: 77776

77776

Parent Item: D2435

D2435

Parent Item Name: Bearpaw, 206

Start Date: 21/12/2011

Required Date: 06/01/2012

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		120	sf	323.6443	3.2	25.6			

MUHMWB10

**

IB12-1-10

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT019

323.6443158

117321

74.6

117738

95.8

117819

83.3

118814

1.5

119145

68.4443158

100835

10

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DART AEROSPACE LTD		Work Order: 77776
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010				FK-04	Vern.
B	5.500	+/-0.030	5.500	✓		"	
C	0.200	+/-0.030	.199	✓		FK-06	Depth gauge
D	R0.250	+/-0.030	.250	✓		rad gauge	
E	0.250	+/-0.010	.240	✓		FK-04	Vern.
F	0.625	+/-0.030	.622	✓		"	"
G	0.25 x 45°	+/-0.030	.25 x 45°	✓		"	"
H	0.375	+/-0.010	.383	✓		"	"
I	19.000	+/-0.030	19.000	✓		FK-05	Tape
J	0.950	+0.030/-0.010	.949	✓		FK-04	Vern.
K	Ø0.260	+0.005/-0.000	.260	✓		"	"
L	Ø0.930	+/-0.030	.929	✓		"	"
M	0.30	+0.030/-0.000	.309	✓		FK-06	Depth gauge
N	0.375	+/-0.030	.384	✓		FK-04	Vern.
O	7.375	+/-0.030	7.375	✓		FK-05	Tape
P	4.250	+/-0.010	4.250	✓		FK-04	Vern.
Q	2.000	+/-0.030	2.000	✓		"	"
R	9.000	+/-0.010	9.000	✓		CNC-02	Vern.
S	15.750	+/-0.030	15.750	✓		FK-05	Tape

Measured by: FK	Audited by: DR	Prototype Approval: N/A
Date: 12/02/22	Date: 12-2-25	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

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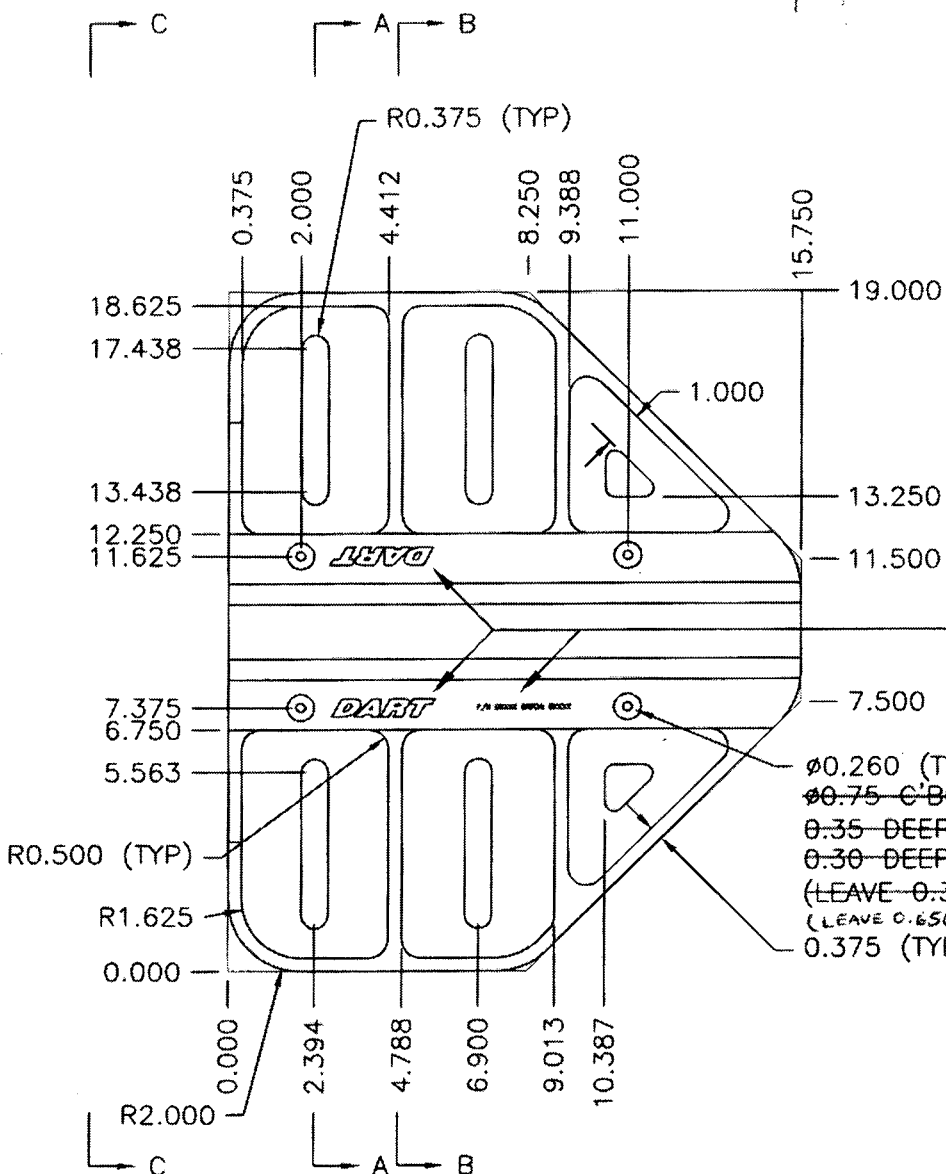
NOTE: Date & initial all entries



QA COPY ISSUED

RELEASED
19.06.17 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. E
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	SHEET 1 OF 2	
DATE 98.05.19	TITLE BEARPAW		SCALE	1:5

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



~~0.260 (TYP) Ø 0.93 C'BORE~~
~~Ø 0.75 C'BORE 0.30 DEEP FROM BOTTOM~~
~~0.35 DEEP FROM TOP (MIN.)~~
~~0.30 DEEP FROM BOTTOM~~
~~(LEAVE 0.300 MIN.)~~ 
~~(LEAVE 0.650 MIN.)~~
 0.375 (TYP) 

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

Copyright 1996 by DART AEROSPACE LTD

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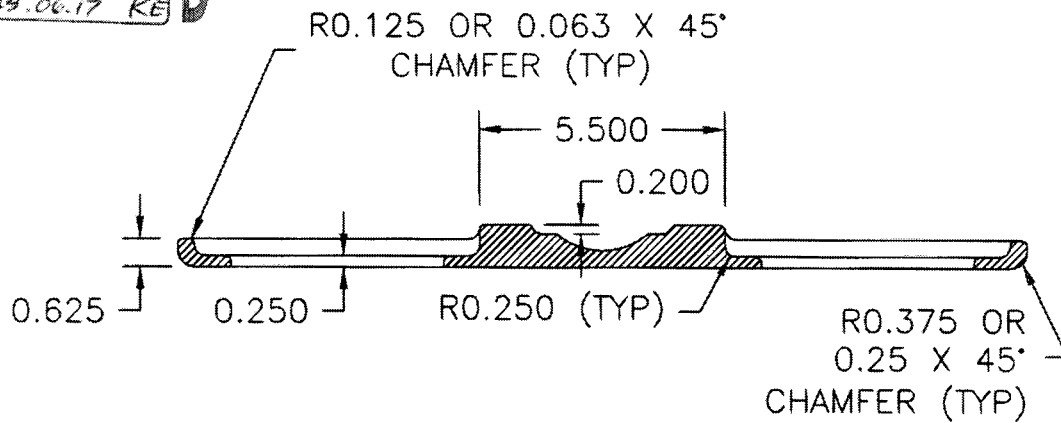
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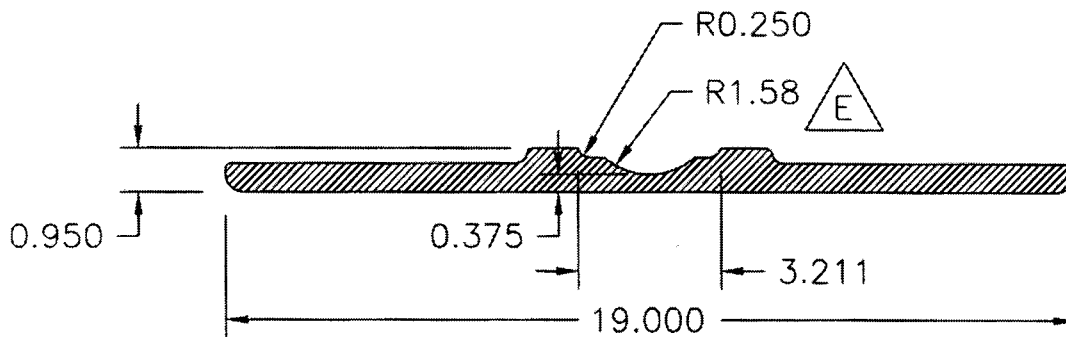


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED BME	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19	TITLE BEARPAW		SCALE 1:4

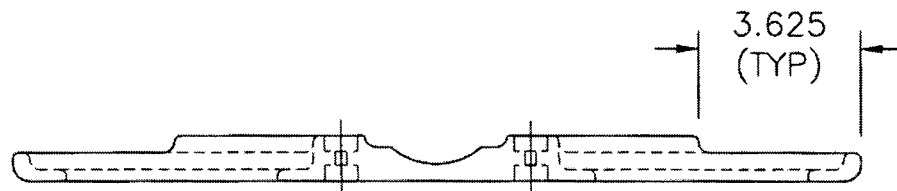
RELEASED
99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

2435

W/O:		WORK ORDER CHANGES					
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